



# Green Corps™ Grinding Discs

The Premium Choice for Stainless Steel Applications-  
Durability with faster cut and a better finish



# 3M™ Green Corps™

## Flexible Grinding Discs & Rigid Grinding Discs



The Green Corps Grinding Discs contain 3M's patented Cubitron™ abrasive grain, an advanced ceramic aluminum oxide mineral, that features distinguished toughness, high stock removal, and anti-loading property. These type 27 depressed center grinding discs enable you to improve your production standards for grinding and blending on a wide selection of metals, especially on stainless steel.



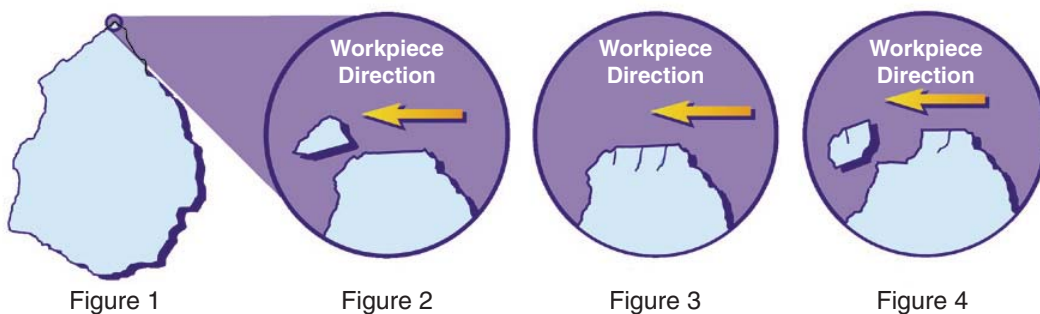
The following characteristics provide value and increased performance in a variety of demanding applications:

- Fast cut rate increases work efficiency
- Durability provides long life
- Minimal vibration reduces operator fatigue
- Fewer abrasive steps increases throughput

### Cubitron™ Abrasive Grain



When you see the Cubitron mark, you are getting a sol gel mineral (1) that sharpens as it wears. Initial grinding breaks away small edges of the grain (2). As grinding continues, micro-fractures form (3) which break off to create fresh sharp edges for continued fast cutting (4). This process repeats throughout grinding for long-term efficiency and full value for your abrasive investment.





# 3M™ Green Corps™ Flexible Grinding Discs

The Green Corps flexible grinding disc is an aggressive grinding disc for right angle tools and is specially designed to have the flexibility of a fibre disc and the versatility of a type 27 grinding disc.

Because of its flexibility, the Green Corps flexible grinding disc puts more grinding surface on the job resulting in faster cut and finer finish. Its unique 1/8" thickness feature also results in reduced vibration and operator fatigue during operation.



**Application:**

Suitable for all grinding operation, especially for grinding, blending, descaling and finishing on contour surfaces. Can be used for all ferrous metal, with excellent performance on stainless steel.

**Industry:**

Recommended for use in Automotive Manufacturing, Shipyards, Construction, Metal Fabrication, General Metal Working.



Always use Backup Pad on all flexible grinding disc for safety, optimum performance and durability of disc.

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# 3M™ Green Corps™ Rigid Grinding Discs

The Green Corps rigid grinding disc is a 1/4" thick depressed center disc for right angle tools and is designed to provide high rate of stock removal and long life to meet all your toughest grinding needs.



**Application:**

Suitable for all stock removal and heavy duty grinding operations. Can be used for all ferrous metal, with excellent performance on stainless steel.

**Industry:**

Recommended for use in Automotive Manufacturing, Shipyards, Maintenance and Construction, Metal Fabrication, General Metal Working.

**Safety First**

Always use properly guarded tools, follow maximum operating speed recommendations and wear proper face and body protection

## Product Availability

### 3M™ Green Corps™ Flexible Grinding Discs

Size	Dimension (mm)	Grade	Discs/Box	Stock Number	MOS
4"	100x3x16	36	20	XC002509476	80m/s, 15,300rpm
	100x2x16	46	20	XC002509484	80m/s, 15,300rpm
	100x2x16	60	20	XC002509492	80m/s, 15,300rpm
	100x2x16	80	20	XC002509500	80m/s, 15,300rpm
4-1/2"	115x3x22	36	20	XC002031349	80m/s, 13,300rpm
	115x3x22	46	20	XC002031356	80m/s, 13,300rpm
	115x3x22	60	20	XC002031364	80m/s, 13,300rpm
	115x3x22	80	20	XC002037304	80m/s, 13,300rpm
5"	125x3x22	36	20	XC002032198	80m/s, 12,200rpm
	125x3x22	46	20	XC002032206	80m/s, 12,200rpm
	125x3x22	60	20	XC002032214	80m/s, 12,200rpm
	125x3x22	80	20	XC002032222	80m/s, 12,200rpm
7"	180x3.7x22	36	20	XC002032230	80m/s, 8,500rpm
	180x3.7x22	46	20	XC002032248	80m/s, 8,500rpm
	180x3.7x22	60	20	XC002032255	80m/s, 8,500rpm
	180x3.7x22	80	20	XC002032263	80m/s, 8,500rpm

### 3M™ Green Corps™ Rigid Grinding Discs

Size	Dimension (mm)	Grade	Discs/Box	Stock Number	MOS
4"	100x6x16	24	25	XC002057088	71m/s, 13,800rpm
7"	180x6x22	24	10	XC002057393	80m/s, 8,500rpm

### ACCESSORIES: Backup Pads (For Flexible Grinding Discs)

Dimension (mm)	Pads/Box	Stock Number
Back Up Pad for 4" Flexible Grinding Disc	5	XC002510276
Back Up Pad for 4-1/2" and 5" Flexible Grinding Disc	5	XC002038252
Back Up Pad for 7" Flexible Grinding Disc	5	XC002038276



**Product Use:** All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

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**Safety Information:** Always use appropriate protective glasses, face shields and body protection. Do not exceed maximum operating speeds. Use guards provided with machine. Follow safety operation procedures posted in work areas.



Abrasive Systems Division

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